

Work Order ID 61179

August 11, 2010 7:42:35 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/17/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: C2 Date: 10/8/11 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A								

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

SAD 10-08-12

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: 1114649

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

6 RD 10.08.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item ID: D3825-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly (Basket End)
Start Date: 8/11/10 Start Qty: 6.00  Cust Item ID:
Required Date: 8/17/10 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	<i>12</i>	<i>10.08.19</i>		<i>6</i>	<i>β</i>		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>8</i>	<i>10.08.19</i>		<i>He</i>			
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>Basket</i> Memo	0.00 0.00				<i>6</i>	<i>10.08.19</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/17/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/08/19 AJ

MF
10-8-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61179



Parent Item: D3825-041



Parent Item Name: Rib Assembly (Basket End)

Start Date: 8/11/10

Required Date: 8/17/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3 Spacer Bushing		Manufactured	No			100	Each	17.0000	1	6			
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Location	Loc Qty	Loc Code
WA	17	
58406	1	
58974	1	
60320	15	

D3759-1 Bushing		Manufactured	No			100	Each	119.0000	1	6			
--------------------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST084	60	
56942	60	
WA	59	
54072	9	
60241	8	
60719	42	

M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	489.2170	2.125	13.42105			
---	--	-----------	----	--	--	-----	---	----------	-------	----------	--	--	--

Location	Loc Qty	Loc Code
MAT	1.4628	
112398	0	
114482	1.4628	
WA	487.754185	
114520	22.417985	
115274	465.3362	

PD 10.08.19

6
PD 10.08.19

6
SAD 10-08-12

6.7106
6.7106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

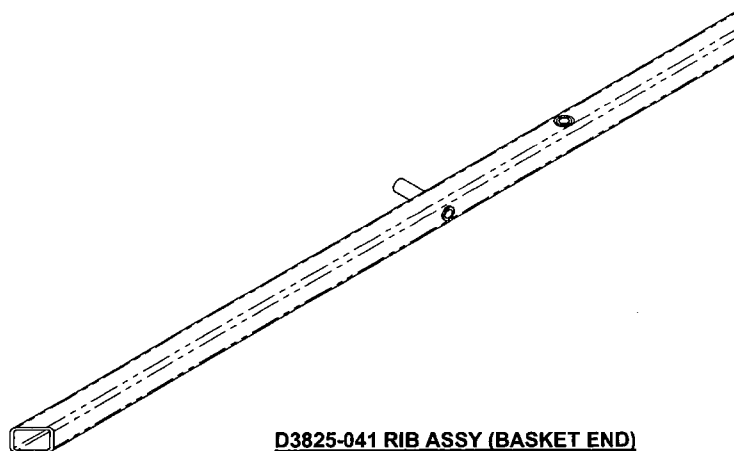
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 601179
C21018111

RELEASED
08/11/18

NOTES:

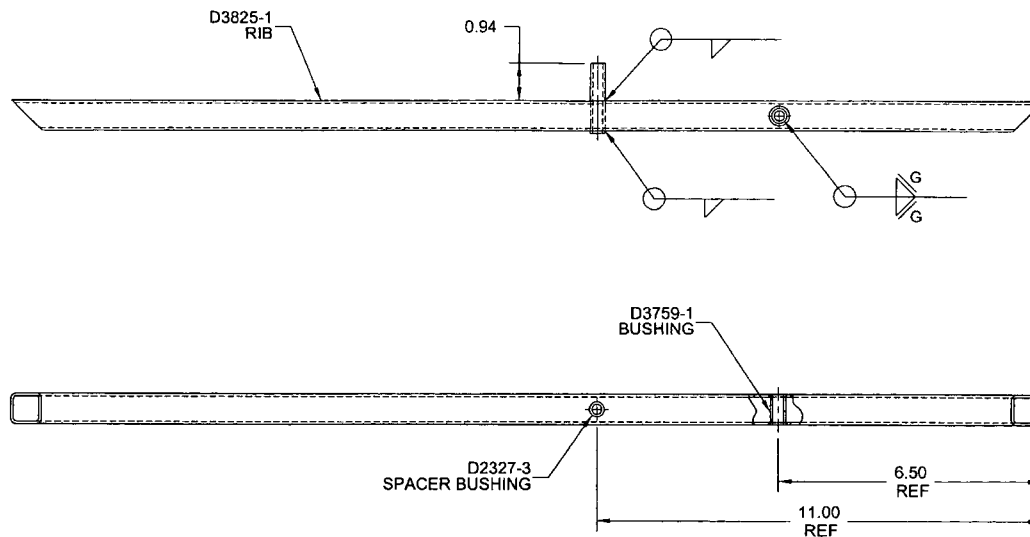
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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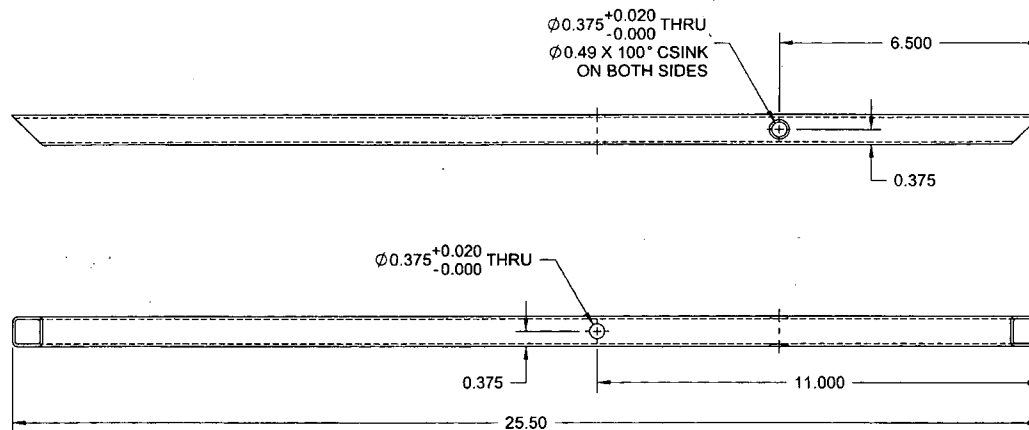
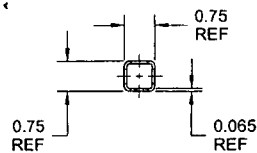


D3825-041 RIB ASSY (BASKET END)

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WORK ORDER
NO. 61179

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D3825-1 RIB

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WORK ORDER
NO. 61179

RELEASED
08/11/13 MP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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